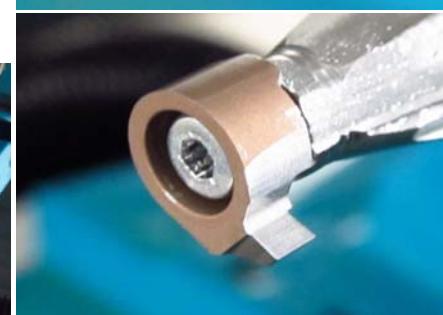


Grooving Insert Ø9.6 Z1

A08-250

The special grooving insert is ground in one setup. The probe operation measures the cutting edge position of the sintered blank. The grooving profile is ground with 2 wheels, used for a pregrinding and a finishing process. The chipbreakeroperation has been ground with a wheel of diameter 125 mm. For automatic loading the insert is clamped with adapted TTC-clamping. The chipbreaker is designed with defined convex and concave radii at the bottom ending with defined angle into the outerdiameter.



1. Cycletime for Production

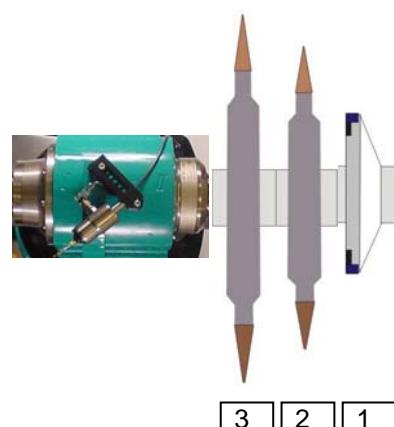
Workpiece:	special blank 3.9x9.6 Material CARBIDE			
Operations	Probe	Chipbreaker	Pregrinding	Finishing
Feed [mm/Min]	2000	100	20	50
Power [kW]		1	1	1
Cutting speed [m/s]		22	22	22
Used wheels				
Grinding time [s]	10	35	46	21
Total cycle time	1 Min 52			



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12A2 Ø125 D64
2	14EE1 Ø200 D76V20°
3	14EE1 Ø250 D46V20°



3. Machine and Software Requirements

Machines:	5 axes CNC grinders : SIRIUS HPM	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 310i	Software:	Quinto 5
Accessories:	TTC Clamping, Robot		

Responsible engineer: OP. 27.12.11

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